



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.2511

Job Sheet 193731



Part No: 647.2511

Job Qty: 20 pcs

Part Name: Nut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/22/19

Job Tracking No:

Due Date: 5/1/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 647.2500 REV.A IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED BY:DD IPP REV:B 19.02.27 AS PER
DWG REV.A DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	20 pcs	5/1/19	5/1/19	0.00	9.53	Doosan - 1		JSD 19/05/19
110	QC 2	20 pcs	5/1/19	5/1/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S180899



Part: 647.2511

Job No: 193731

Serial No/Batch: S180899

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/27/19

Plex 4/22/19 10:24 AM Dart.lajeunesse.marie

140 QC 8	20 pcs	5/1/19	0.00 0.00	QC 2 - 65	JBD 19/05/19
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	mm L 19/05/20
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
150 Outsource - 17 - Passivate	20 pcs	5/1/19		GRO002-VC	7 2019-05-20
160 Packaging 2-1 - Receive - B4B	20 pcs	5/1/19	0.00 0.00	Packaging 2 - 1 - B4B	S. MAY 27 2019
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	

170 QC 5	20 pcs	5/1/19	0.00 0.00	Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
180 Packaging 3-1 - Stock - B4B	20 pcs	5/1/19	0.00 0.00	QC 5 - 40	DAS 46 9-85 MAY 27 2019
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	CKM MAY 27 2019
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAS 21 9-85
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	20 pcs	5/1/19	0.00 0.00	QC 21 - SA - 21	MAY 27 2019

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 100 - (Doosan Lathe) 1- Turn as per Folio FB144 AND DWG DWG Rev: A FOLIO Rev: Am -Deburr per dwg
 Descriptions: ***CHECK THREADS USING GO/ NO GO GAUGE*****

110 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check) 100% CHECK,CHECK ALL DIMENSIONS AND THREAD FIT

150 - Issue P/O: _____ Pasivate as per MIL-S-5002 TYPE 6 Certificate of conformity is required

160 - (Receive & Inspect for Damage & Mat'l Certs) Ensure certificate of conformity is attached

170 - (QC5- Inspect part completeness to step on W/O)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R1.000	17-4 SS Round Bar 1.000"	1 ft (.05 ea) <u>.0656</u>	100-Doosan - 1	<u>5172297</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M17-4-H1150-R1.000	1	13	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Nut	0.875Inches ± 0.010	0.885 0.865		<u>.874</u>
2	Nut	0.530Inches ± 0.010	0.540 0.520		<u>.536</u>
3	Nut	90.000Degrees ± 0.500	90.500 89.500	Angle	
4	Nut	0.660Inches ± 0.010	0.670 0.650		<u>.6595</u>
5	Nut	0.130Inches ± 0.010	0.140 0.120		<u>.131</u>
6	Nut	0.580Inches + 0.000 - 0.002	0.580 0.578		<u>.579</u>
7	Nut	0.590Inches ± 0.010	0.600 0.580		<u>.581</u>

Plex 4/22/19 10:24 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S180899



Part: 647.2511

Job No: 193731

Serial No/Batch: S180899

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

Date: 05/14/19



E-MAILED
2019-05-22

**DAS
40
9-89**



Certificat de Conformité / Certificate of Compliance

(019378-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupealtech.com

Bon de Livraison / Packing Slip

019378- 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
22-May-2019		SVETLANA DORZHIYEVA				POHB043501				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)			CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	647.2511 Rev.	647.2511 01 -PASSIVATION-BICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF:-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvant if required remove any markings, paintor and heavy contaminants. TERRY LINE			PASSIVATION CH	20	20	0	0	0

DAS
40
9-89

RECEIVED

MAY 24 2019

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

1 BOX

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.